



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2654-5
Job Sheet 168332



Part No: D2654-5

Job Qty: 16 ea

Part Name: Web



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV F SHEET 2 IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Skid tubes		TH
100	Skid tubes	16 pcs	11/23/17	11/23/17	0.00	8.74	Skid tubes		3.4
110	QC	16 pcs	11/23/17	11/23/17	0.00	0.00	QC5		BK
120	HandFinish	16 pcs	11/24/17	11/24/17	0.00	3.81	HandFinish1		2017-11-21 JSC
130	QC	16 pcs	11/24/17	11/24/17	0.00	0.00	QC7		BK
140	Packaging	16 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		MEG
150	QC21-SA	16 Ea	11/24/17	11/24/17	0.00	0.00	QC21		21 NOV 22 2017

Part Op 100 - 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654
Descriptions: 140 - LOCATION : LG002

Job Allocations

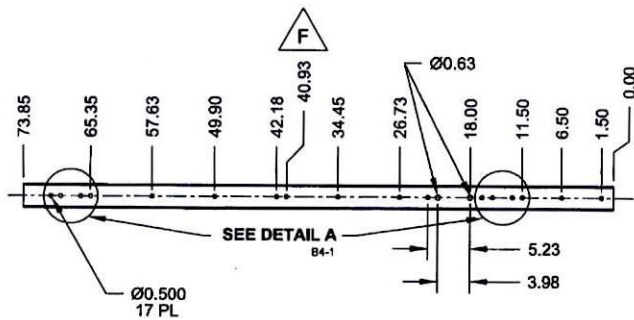
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-7-140 8162496	16	49	0	0

Part Specifications

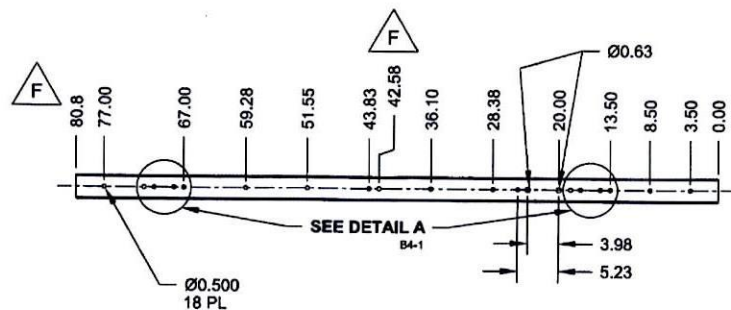
Specifications could not be found.

Plex 11/13/17 1:37 PM dart.poulin.mario

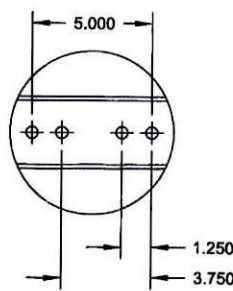
168332



D2654-1 WEB



D2654-3 WEB



DETAIL A

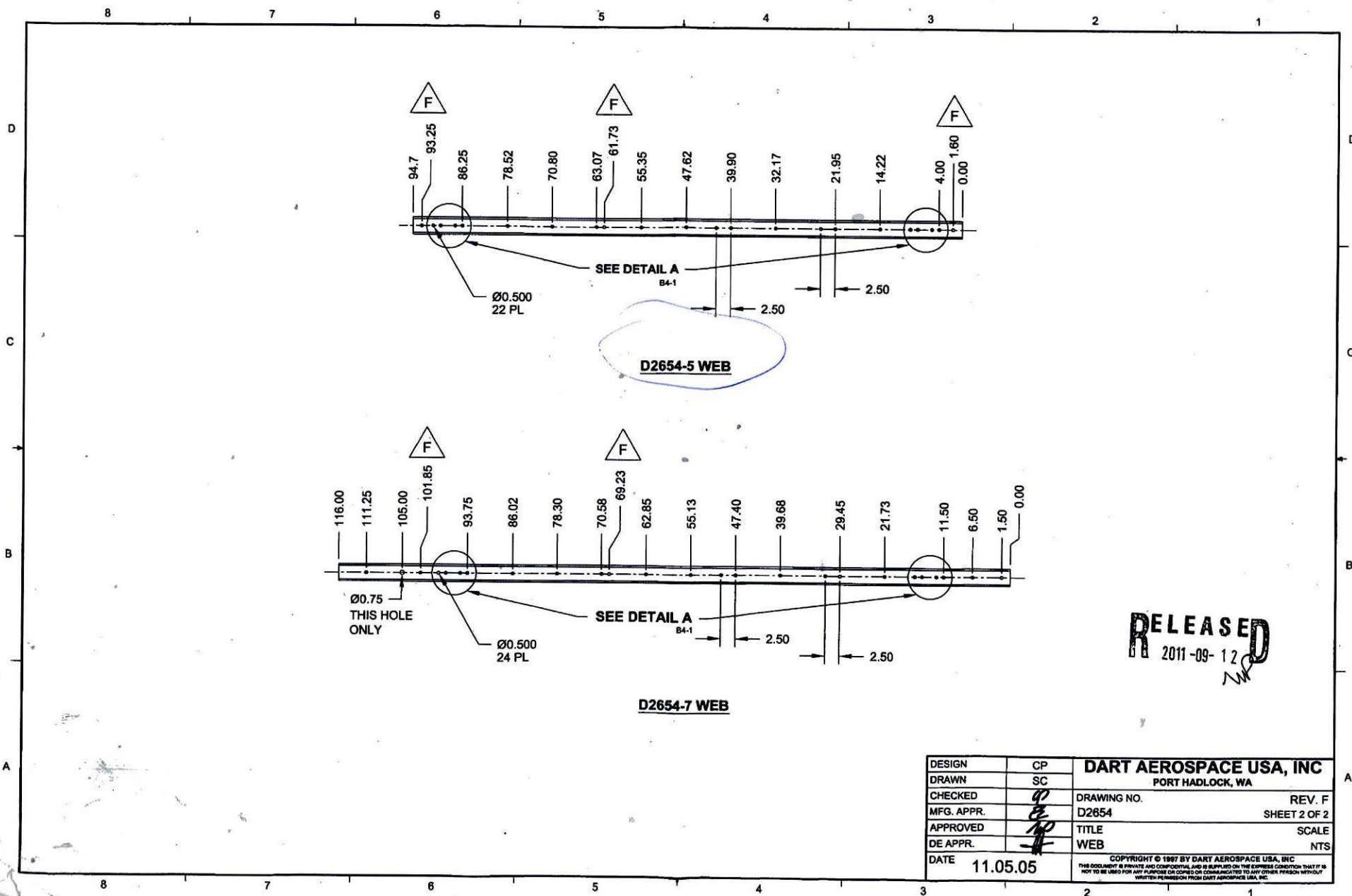
C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

RELEASED
2011-09-12

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.08.28
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	92	DRAWING NO.	REV. F
MFG. APPR.	92	D2654	SHEET 1 OF 2
APPROVED	92	TITLE	SCALE
DE APPR.	92	WEB	NTS
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DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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